Blade Sandtex Ship June 1

# Work Order ID 59068

*May 26, 2010 7:39:31 AM*



**Item ID:** D350-591-312 **Accept**

**Setup** Start / Stop

**Revision ID:**

**Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Start Qty:** 1.00

**Required Date:** 6/01/10 **Req'd Qty:** 1.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** Start / Stop

**Approvals:** **Process Plan:** ✓ **Date:** ____ **Tooling:** ____ **Date:** ____

**QC:** ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D3272 | Rev B |

100 — DOCUMENT CONTROL — 0.00

DC

Document Control

**Memo** 0.00

Photocopy bluefile and type labels as per PPP D350-591-312 ~~CHG001~~ CHG002 S 010601

I put Red Labels on S 010601

110 — Large Fab — 0.00 — 10.05.27

Large Fab

Large Fab

**Memo** 0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M112860 M114242

3-Grind End Plate flush

# Work Order ID 59068

*May 26, 2010 7:39:32 AM*

**Item ID:** D350-591-312 **Accept**

**Revision ID:**

**Item Name:** Heli-Access-Step, Long RH

**Setup** Start / Stop

**Start Date:** 5/26/10 **Start Qty:** 1.00

**Required Date:** 6/01/10 **Req'd Qty:** 1.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** Start / Stop

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | 1 | PD 10.05.27 | | |
| | Memo | 0.00 | | | | | | | |
| 130 QC Quality Control | QC5- Inspect part completeness to step on W/O | 0.00 | S 10/05/27 | | | (41 RM) | | | |
| | Memo | 0.00 | | | | | | | |
| 140 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 | 0.00 | 10.05.27 | | | 1 | 0 | | |
| | Memo | 0.00 | | | | | | | |

# Work Order ID 59068

*May 26, 2010 7:39:39 AM*

**Item ID:** D350-591-312 **Accept**

**Setup** **Start**

**Revision ID:**

**Stop**

**Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 6/01/10 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Run** **Start**

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

**Stop**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 150<br>QC<br>Quality Control | QC3- Inspect Part Finish<br>**Memo** | 0.00<br>0.00 | SAP 10-05-27 | | | (1) | | | |
| 180<br>Large Fab<br>Large Fab | Large Fab<br>**Memo**<br>1-Assemble Leg Assembly as per Dwg D3272.<br>2-Leave one rivet out until welding is complete.<br>3-Bevel Aft end for welding<br>4-Inspect for foreign object as per QSI 024<br>5-Weld Aft End Plate as per QSI 004 & Dwg D3272<br>A/R□□Aluminum Rod□ m112860<br>6-Grind End Plate flush<br>7-Install last rivet as per Dwg. | 0.00<br>0.00 | [signature] 10-05-28 | | | 1 | Ø | | |

# Work Order ID 59068

*May 26, 2010 7:39:39 AM*

**Item ID:** D350-591-312 **Accept**

**Setup** Start / Stop

**Revision ID:**

**Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 6/01/10 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Run** Start / Stop

**Approvals:** **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

**QC:** ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 190<br>QC<br>Quality Control | QC9- Inspect visual per QSI004- Fusion Welds<br>**Memo** | 0.00<br>0.00 | | | | 1 | | | 10.05.28 |
| 200<br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br>**Memo** | 0.00<br>0.00 | 10/05/26 | | | +1 RH | | | |
| 210<br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br>**Memo** | 0.00<br>0.00 | | | | 1 | | | BR 10-5-31 |

**Work Order ID 59068**

*May 26, 2010 7:39:44 AM*

**Item ID:** D350-591-312 **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 6/01/10 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 220<br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br>**Memo** M112588<br>POWDER COAT BLACK SANDTEX PER QSI005<br>START TIME: 6:45am<br>OVEN TEMPERATURE: 3 I00 F<br>FINISH TIME: 7:15am | 0.00<br>0.00 | =) H 10/06/01 | | | 1 | 0 | | |
| 230<br>HandFinish<br>Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch 114432<br>**Memo** | 0.00<br>0.00 | | | | 1 | BR 10-6-1 | | |
| 240<br>QC<br>Quality Control | QC3- Inspect Part Finish<br>**Memo** | 0.00<br>0.00 | S 10/06/01 | | | +1 RH | | | |

M

# Work Order ID 59068

*May 26, 2010 7:39:44 AM*

**Item ID:** D350-591-312 **Accept**

**Setup** Start / Stop

**Revision ID:**

**Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Start Qty:** 1.00

**Required Date:** 6/01/10 **Req'd Qty:** 1.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** Start / Stop

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 250<br>Packaging<br>Packaging | Pick Kit<br>**Memo** | 0.00<br>0.00 | | | | 1 | 0 | 6-1 | |
| 260<br>QC<br>Quality Control | QC4- 100% Inspect kits for completeness<br>**Memo** | 0.00<br>0.00 | | | | 1 | | | RH |
| 270<br>Packaging<br>Packaging | Packaging<br>**Memo**<br>Identify and pack for shipping as per PPPD350-591-312<br>Location:______ | 0.00<br>0.00 | | | | 1 | | | |

# Work Order ID 59068

*May 26, 2010 7:39:50 AM*



**Item ID:** D350-591-312

**Accept**

**Setup** **Start**

**Stop**

**Revision ID:**

**Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Start Qty:** 1.00

**Required Date:** 6/01/10 **Req'd Qty:** 1.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** **Start**

**Stop**

**Approvals:** **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

**QC:** ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 280 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | 10/06/01 | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MF
10-6-1

# Picklist Print

*May 26, 2010 7:39:28 AM*



6

**Work Order ID:** 59068

**Parent Item:** D350-591-312

**Parent Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Required Date:** 6/01/10

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:**
IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

D3067-1 — End Plate — Manufactured — No — 110 — Each — 97.0000 — 1 — 1 10.05.27

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| WA | | 97 | | |
| | 57926 | 97 | | 1 |

D3272-1 — Step — Manufactured — No — 110 — Each — 0.0000 — 1 — 1 10.05.26 359069

D3065-041 — Step Leg Assembly Hi — Manufactured — No — 180 — Each — 24.0000 — 1 — 1 10.05.28

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| WA | | 24 | | |
| | 56827 | 8 | | |
| | 58160 | 16 | | 1 |

D3066-1 — Spacer — Manufactured — No — 180 — Each — 177.0000 — 2 — 2 10.05.28

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| WA | | 177 | | |
| | 57920 | 77 | | 2 |
| | 58540 | 100 | | |

D3067-1 — End Plate — Manufactured — No — 180 — Each — 97.0000 — 1 — 1 10.05.28

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| WA | | 97 | | |
| | 57926 | 97 | | 1 |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

**Work Order ID:** 59068

**Parent Item:** D350-591-312

**Parent Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Required Date:** 6/01/10

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:**
IPP Rev:A□04.03.22□New issue □KJ/RF□
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

| Item | Type | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3219-1<br>Plate | Manufactured | No | 180 | Each | 77.0000 | 2 | 2 | 10·05·27 |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| WA | 77 | | |
| 58550 | 77 | | 2 |

| Item | Type | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| MS20600-AD4W4<br>Rivets | Purchased | No | 180 | Each | 683.0000 | 16 | 16 | 10·05·28 |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| ST321 | 683 | | |
| 113368 | 62 | | |
| 114181 | 321 | | 16 |
| 114718 | 300 | | |

| Item | Type | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| AN3-35A<br>Bolt | Purchased | No | 250 | Each | 71.0000 | 2 | 2 | 10-6-1 |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| ST353 | 71 | | |
| 112314 | 1 | | 1 |
| 114382 | 50 | | 1 |
| 114523 | 20 | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: _______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | | | Corrective Action Section B | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

**Work Order ID:** 59068

**Parent Item:** D350-591-312

**Parent Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Required Date:** 6/01/10

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:**
IPP Rev:A□04.03.22□New issue □KJ/RF□
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

| Item | Alt | Type | | Lead | UOM | On Hand | Qty | Issued |
|---|---|---|---|---|---|---|---|---|
| AN4-13A Bolt | | Purchased | No | 250 | Each | 413.0000 | 8 | 8 10-6-1 SP |
| AN5-36A Bolt | | Purchased | No | 250 | Each | 87.0000 | 2 | 2 10-6-1 SP |
| AN960JD10 Washer | NAS1149D0363J | Purchased | No | 250 | Each | 0.0000 | 4 | 4 M114292 10-6-1 SP |
| AN960JD416 Washer | NAS1149D0463J | Purchased | No | 250 | Each | 0.0000 | 16 | 16 M114576 10-6-1 SP |
| AN960JD516 Washer | NAS1149D0563J | Purchased | No | 250 | Each | 0.0000 | 4 | 4 M113706 10-6-1 SP |

AN4-13A locations:

| Location | | Loc Qty | Loc Code | Picked |
|---|---|---|---|---|
| ST351 | | 113 | | |
| | 114523 | 113 | | 8 |
| ST357 | | 300 | | |
| | 114752 | 300 | | |

AN5-36A locations:

| Location | | Loc Qty | Loc Code | Picked |
|---|---|---|---|---|
| ST341 | | 87 | | |
| | 114292 | 87 | | 2 |

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| W/O: | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ______

**Resolution:** ____________ **Disposition:** ____________ **QA: N/C Closed:** ______ **Date:** ______

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

**Work Order ID:** 59068

**Parent Item:** D350-591-312

**Parent Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Required Date:** 6/01/10

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:**
IPP Rev:A□04.03.22□New issue □KJ/RF□
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

| Item | Type | | | | UOM | Qty | Req | Picked |
|---|---|---|---|---|---|---|---|---|
| D2230-3 Lug | Manufactured | No | | 250 | Each | 75.0000 | 4 | 4 10-6-1 Sf |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| ST476 | | 75 | | |
| | 57827 | 75 | | 4 |

| Item | Type | | | | UOM | Qty | Req | Picked |
|---|---|---|---|---|---|---|---|---|
| D2618 Bushing | Manufactured | No | | 250 | Each | 73.0000 | 2 | 2 10-6-1 Sf |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| ST020 | | 73 | | |
| | 56892 | 1 | | |
| | 57829 | 72 | | 2 |

| Item | Type | | | | UOM | Qty | Req | Picked |
|---|---|---|---|---|---|---|---|---|
| D2856-400 Abraison Strip | Manufactured | No | | 250 | f | 269.1088 | 0.6 | 0.6 10-6-1 Sf |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| ST403 | | 269.1088 | | |
| | 50593 | 62.0568 | | 5 |
| | 56626 | 207.052 | | |

| Item | Type | | | | UOM | Qty | Req | Picked |
|---|---|---|---|---|---|---|---|---|
| D3235-1 Mounting Lug | Manufactured | No | | 250 | Each | 3.0000 | 2 | 2 10-6-1 Sf B58707 |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| ST471 | | 3 | | |
| | 57921 | 3 | | 1 |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

**Work Order ID:** 59068

**Parent Item:** D350-591-312

**Parent Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Required Date:** 6/01/10

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:**
IPP Rev:A□04.03.22□New issue □KJ/RF□
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

D3278-041 | Manufactured | No | 250 | Each | 30.0000 | 1 | 1 10-6-1

Support Assembly

| Location | | Loc Qty | Loc Code |
|---|---|---|---|
| ST471 | | 30 | |
| | 57952 | 30 | |

MS21042L3 | Purchased | No | 250 | Each | 1,722.000 | 2 | 2 10-6-1

Nut

| Location | | Loc Qty | Loc Code |
|---|---|---|---|
| ST300 | | 1722 | |
| | 113537 | 20 | |
| | 113644 | 202 | 2 |
| | 114523 | 1000 | |
| | 114718 | 500 | |

MS21042L4 | Purchased | No | 250 | Each | 2,629.000 | 8 | 8 10-6-1

Nut

| Location | | Loc Qty | Loc Code |
|---|---|---|---|
| ST139 | | 2 | |
| | 111827 | 2 | |
| ST300 | | 2627 | |
| | 113422 | 80 | |
| | 114523 | 1539 | 8 |
| | 114718 | 1000 | |
| | 9063 | 8 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ________________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

**Resolution:** ________________ **Disposition:** ________________ **QA: N/C Closed:** _________ **Date:** ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*May 26, 2010 7:39:30 AM*

**Work Order ID:** 59068

**Parent Item:** D350-591-312

**Parent Item Name:** Heli-Access-Step, Long RH

**Start Date:** 5/26/10 **Required Date:** 6/01/10

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:**
IPP Rev:A□04.03.22□New issue □KJ/RF□
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

5 MS21042L5 Purchased No 250 Each 516.0000 2 2 10-6-1

Nut

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| ST300 | 516 | | |
| 113523 | 13 | | |
| 113537 | 3 | | |
| 114437 | 100 | | 2 |
| 114449 | 400 | | |

| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| CHECKED | APPROVED | DRAWING NO.<br>D3272 | REV. B<br>SHEET 1 OF 3 |
| DATE<br>07.05.18 | | TITLE<br>STEP ASSEMBLY, HI LONG | SCALE<br>NTS |

| | | |
|---|---|---|
| A | 04.03.01 | NEW ISSUE |
| B | 07.05.18 | D3272-1 WAS D2622-120 |

DART

RELEASED
07 06 04

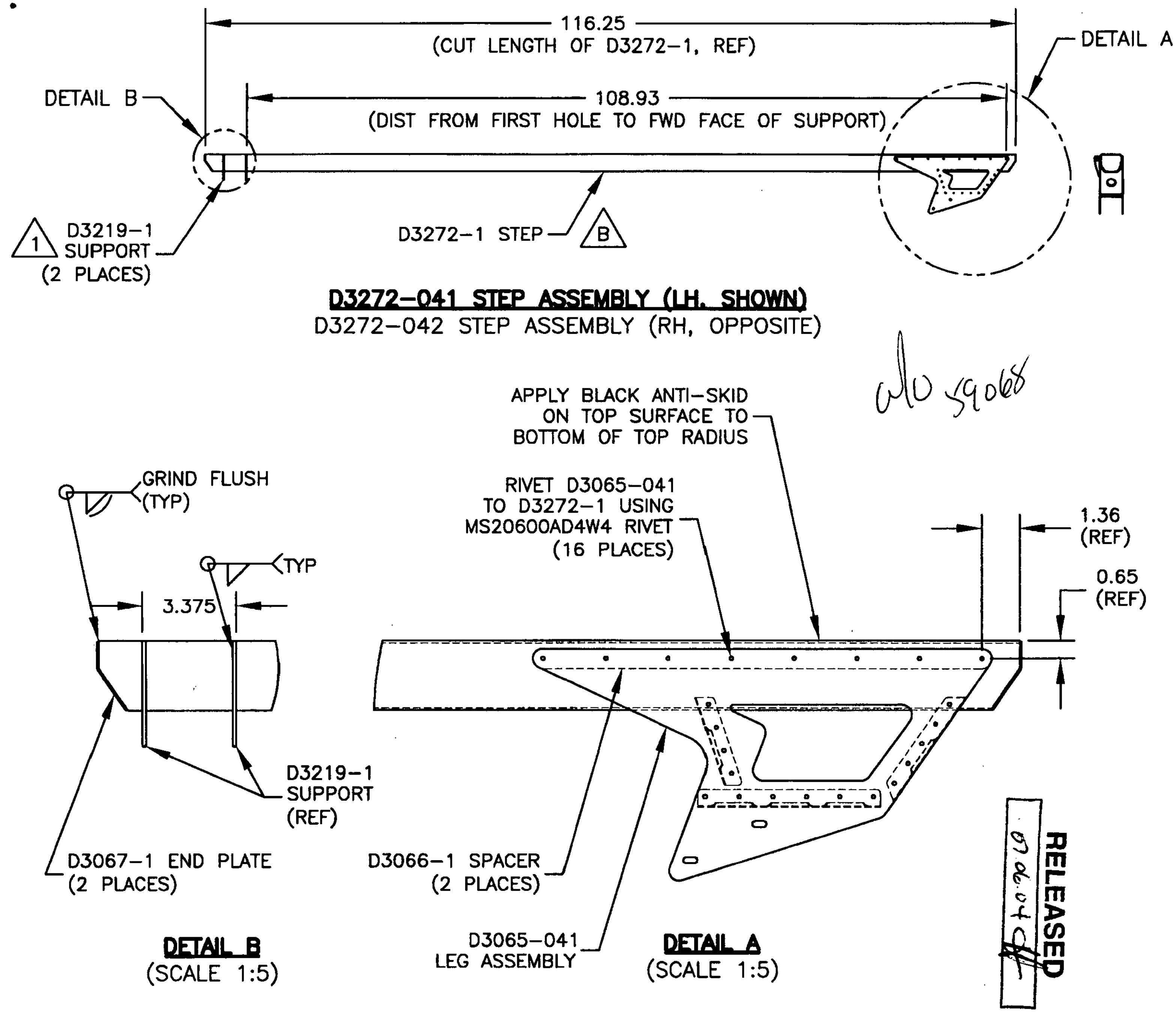
| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|---|---|---|---|
| X | | **D3272-041** | **STEP ASSEMBLY, HIGH LONG (LH)** |
| | X | **D3272-042** | **STEP ASSEMBLY, HIGH LONG (RH)** |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

B (revision mark at D3272-1 row)

**GENERAL NOTES:**

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

a/o 59068




DART

| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| CHECKED | APPROVED | DRAWING NO. D3272 — REV. B — SHEET 2 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG — SCALE 1:20 |

DART

| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| CHECKED | APPROVED | DRAWING NO.<br>D3272 | REV. B<br>SHEET 3 OF 3 |
| DATE<br>07.05.18 | | TITLE<br>STEP ASSEMBLY, HI LONG | SCALE<br>1:20 |

RELEASED 07.06.04

